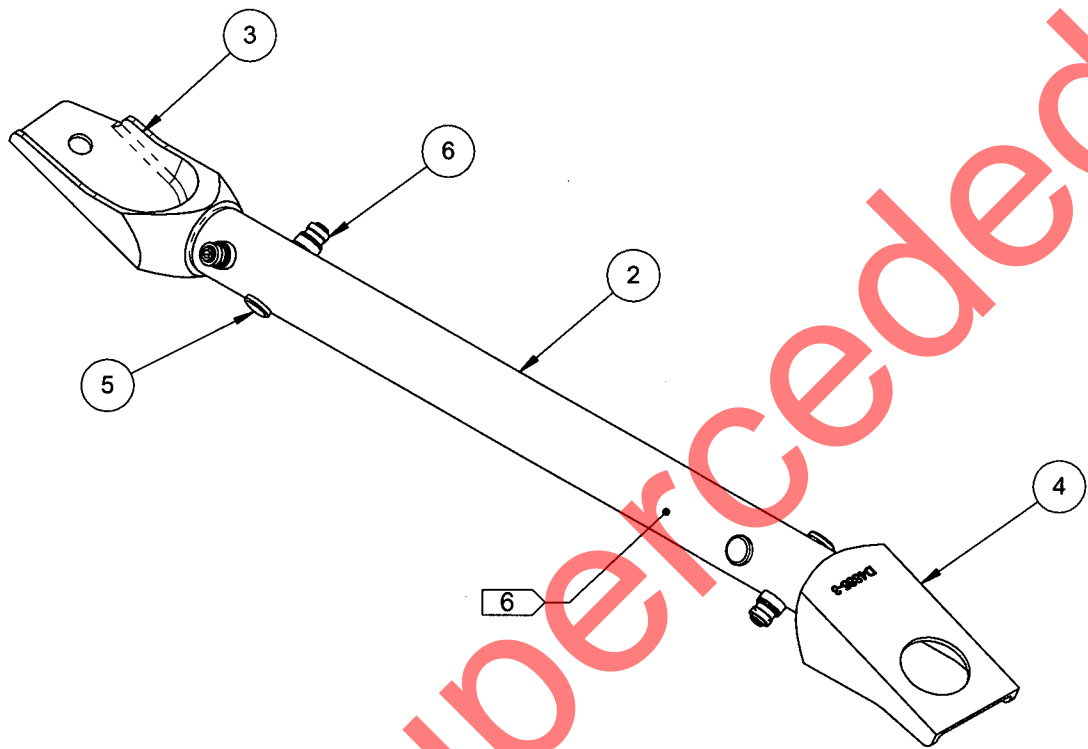


ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



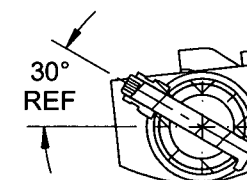
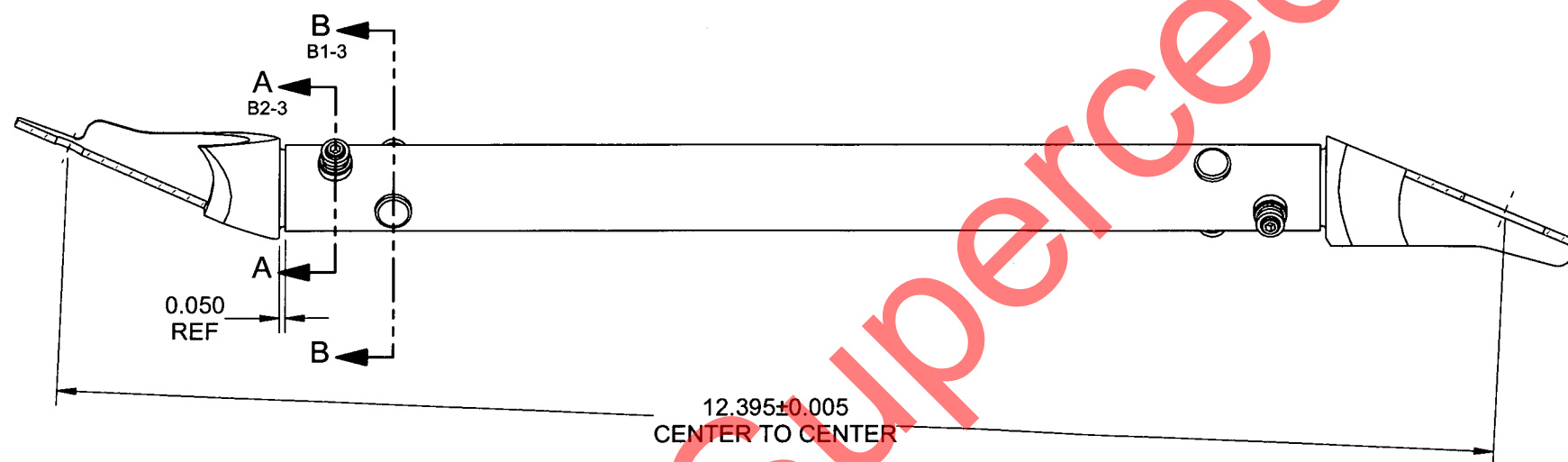
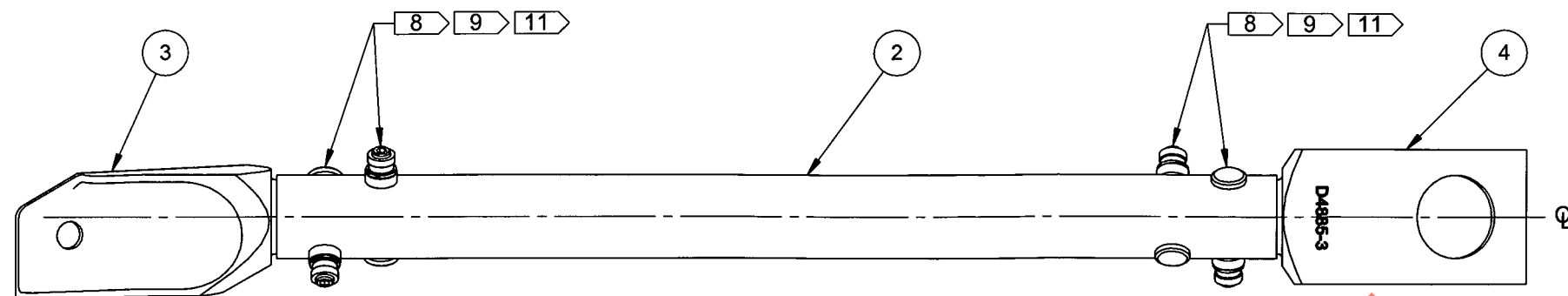
D4881-041 AFT LEG ASSEMBLY, LH

RELEASED  
2013-12-12  
[Signature]

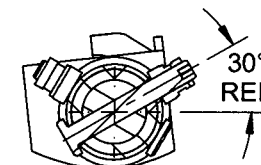
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.72 lbs
  - 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9973
  - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
  - 10) ASSEMBLE PER DART TOOL DT9973
  - 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

A	NEW ISSUE		RF	13.09.16
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	DC	DRAWING NO.		REV. A
MFG. APPR.	JLM	D4881		SHEET 1 OF 5
APPROVED	HS	TITLE		SCALE
DE APPR.	DS	LEG ASSEMBLY		NTS
DATE	13.12.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



**SECTION A-A** C7-3  
2 PL SIMILAR



**SECTION B-B** C7-3  
2 PL SIMILAR

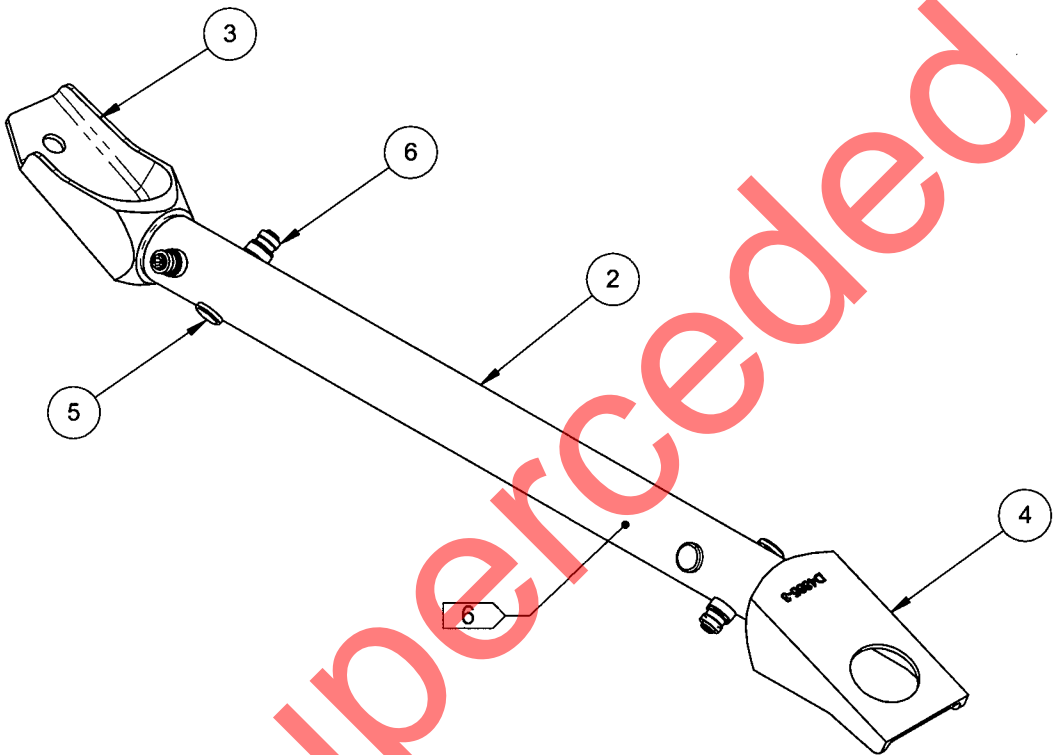
**D4881-041 AFT LEG ASSEMBLY, LH**  
AUXILIARY VIEW

2013-12-12  
MP

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4881</b>	REV. A
MFG. APPR.	JLM		SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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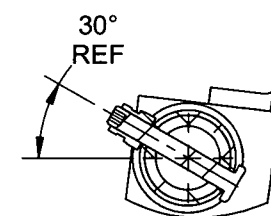
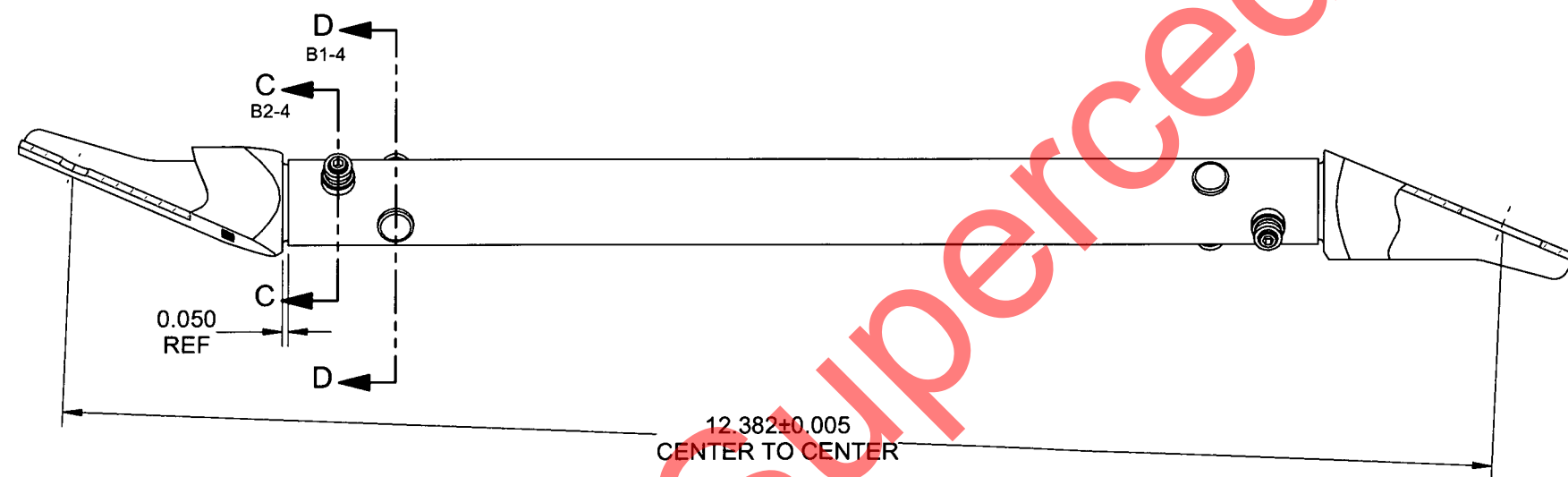
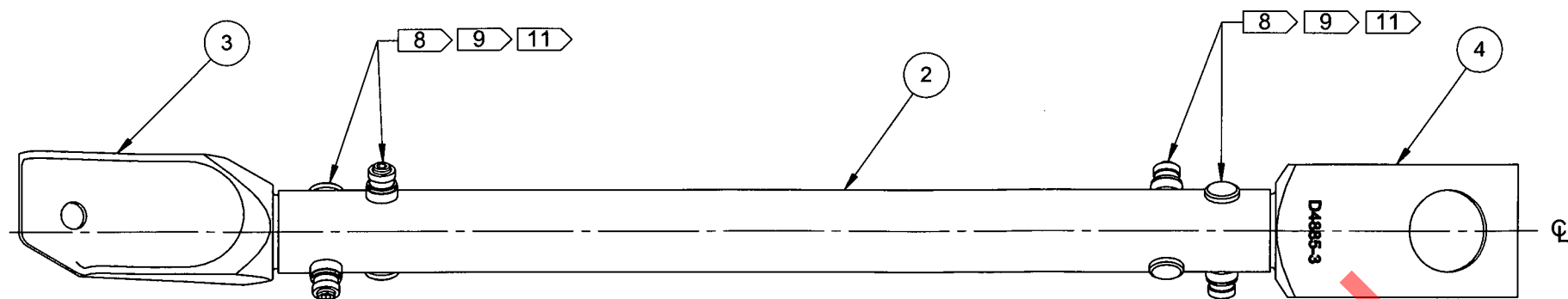
ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4881-042	AFT LEG ASSEMBLY, RH
2	1	D4881-1	STRUT
3	1	D4885-2	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



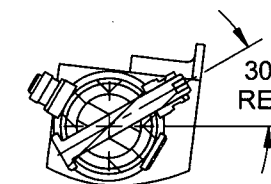
D4881-042 AFT LEG ASSEMBLY, RH

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 0.78 lbs
  - 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9974
  - 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
  - 10) ASSEMBLE PER DART TOOL DT9974
  - 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED	DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	DC	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D4881	SHEET 3 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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**SECTION C-C** C7-4  
2 PL, SIMILAR



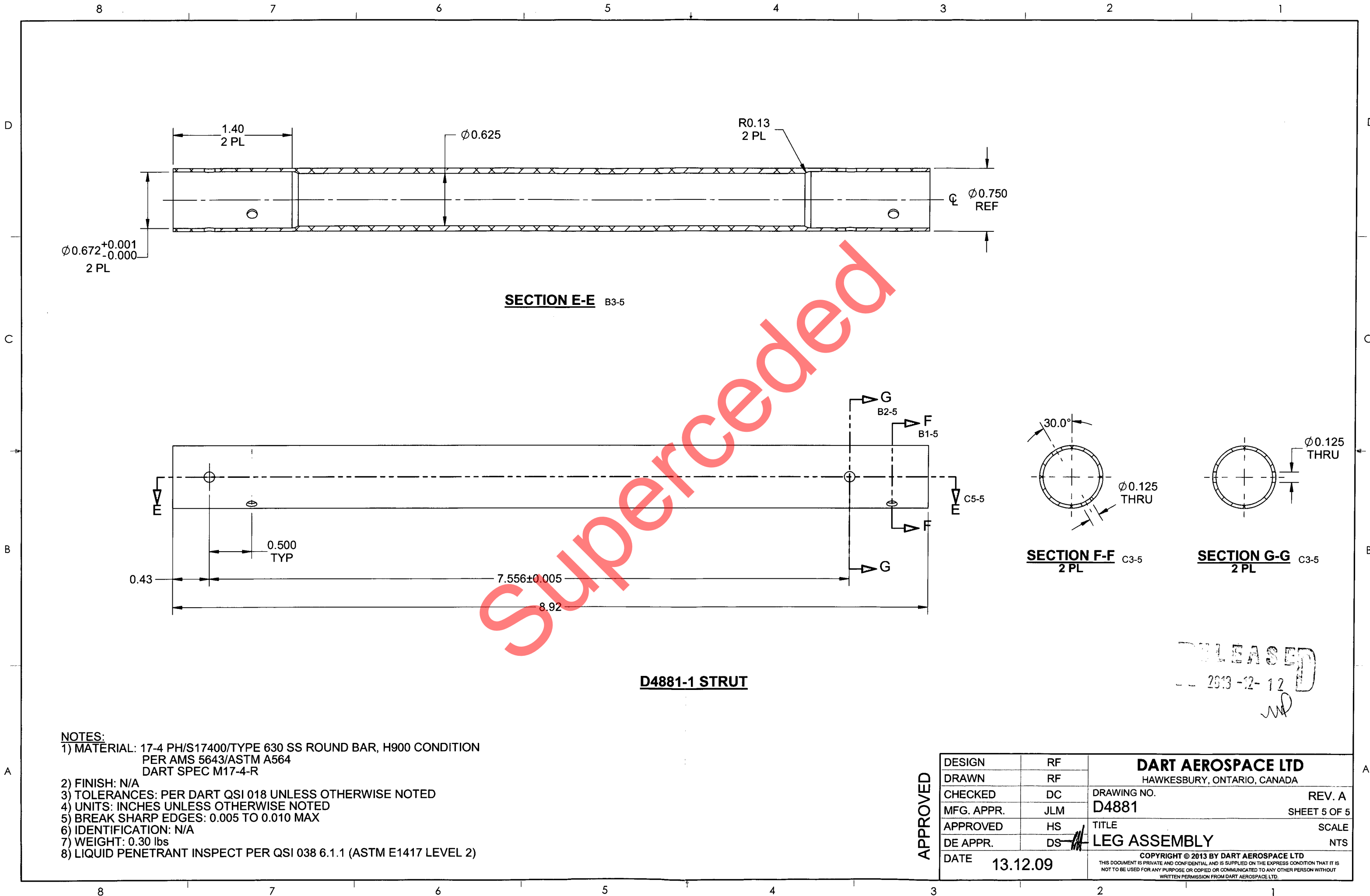
**SECTION D-D** C7-4  
2 PL, SIMILAR

**D4881-042 AFT LEG ASSEMBLY, RH**  
AUXILIARY VIEW

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. <b>D4881</b>	REV. A
MFG. APPR.	JLM		SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>LEG ASSEMBLY</b>	NTS
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2013-12-12



NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPER 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4881	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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